

Work Order ID 161146

161146

Page 1

Monday, May 08, 2017 9:34:15 AM

Item ID: PB67-43001-125

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clevis

Start Date: 5/11/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/19/2017 Req'd Qty: 4.00

4

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan:

DAS

21

Date MAY 08 2017

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

B67-43001

D

100

0.75

100

DOOSAN LATHE

Doosan

Memo

0.83

Doosan Lathe

Turn as per Folio FA & Dwg B67-43001

DAS

33

9-89

17/05/09

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DAS

33

9-89

17/05/09

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

DAS

45

9-89

2017-5-10

PTO

DQA:

Date: 2017-07-10



QA Closed:

Date: JUL 03 2017

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>16146</u> Part No. <u>PB-67-4301-125</u> NCR No. <u>17-6489</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date: <u>17/05/18</u>		Step #: <u>110</u>		QTY Effective :		MRB (QSI042) Approval DAS 9 9-89 <u>17-05-15</u>	
Description Work Order Deviation				Disposition		Completed By 33 9-89 <u>17/05/18</u>	
Port is not too drawing. 300 radius was made on side of part which is not called out on drawing. L.C. Program				scrap destroy + replace. <u>B 136896</u> Remove side rad from program. done by JL 17-5-16		Lead hand / Supervisor Approval Verification <u>B-0 17-05-18</u>	
						QC / QA Coordinator Approval DAS 9 9-89 <u>17-05-31</u>	
Root Cause Environment ☐ Design ☐ Doc/Data ☒ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☒ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :							

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.20

Hand Finishing

(X5) 0 20170518
BEB

140 Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

140

Powdercoat

M 134092

Memo

0.24

Powder Coating

Mask Ø0.880"

START TIME: 3:50OVEN TEMPERATURE: 320FINISH TIME: 4:20

5 0 170525 2349

150 QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

5 0 170525 2349
DAS
38
MAY 29 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Identify as per dwg & Stock Location: UN003

0.00

160

Packaging

Memo

0.00

Packaging

5

DAS
21
9-89

MAY 30 2017

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

17/5/31

DAS
21
9-89

MAY 30 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : ☐																																																															

Picklist Print

Monday, May 08, 2017 9:34:15 AM

Page 1

Work Order ID: 161146

161146

Parent Item: PB67-43001-125

PB67-43001-125

Parent Item Name: Clevis

Start Date: 5/11/2017

Required Date: 5/19/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A05.08.26New issueKJ/JLM
IPP Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R1.000		Purchased	No			100	f	14.7927	0.15	0.808421			
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M6061T6R1 000

ROUND BAR 1.00"

Location

Loc Qty

Loc Code

MAT012

14.7927

m136896

14.7927

M6061T6R1.000		Purchased	No			100	f	14.7927	0.15	0.631579			
---------------	--	-----------	----	--	--	-----	---	---------	------	----------	--	--	--

M6061T6R1 000

ROUND BAR 1.00"

DAS
33
9-89

SK
17-5-16

17105/09

Location

Loc Qty

Loc Code

MAT012

14.7927

m136896

14.7927

2,789' + 1.2

DQA: _____ Date: _____

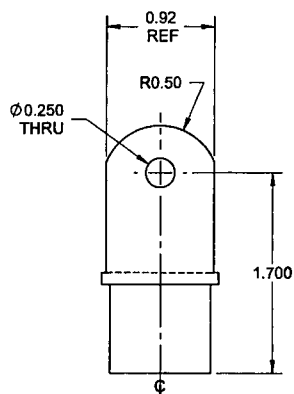
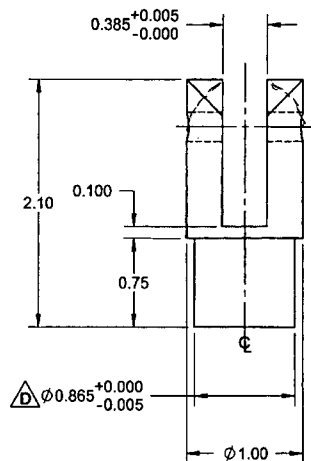


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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161146 M5
170508

B67-43001-125 CLEVIS

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

RELEASED
2016-11-09
6061-T6

D	DIA 0.865 +0.000/-0.005 WAS DIA 0.880 REASON: PAR 15-445	DB	16.05.02
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 34 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	JLM	B67-43001-125	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	CLEVIS	NTS
DATE	16.05.02	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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